

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

507314
18-11-19

Date: 19.01.15	Job No.:	ADR Yes/No: No	ADR Date: N/A	ECN #: 19- 509
Product No.: DART TOOLING EUROCOPTER		Created By: VM	Approved By: <i>mpp</i>	
Product Name:		Checked By: <i>mpp</i>		

Reason for Change:
MATERIAL CHANGED

Documents Released:

RBE105-14101W11 REV B

IF APPLICABLE: NCR: _____ PAR: _____ CAR: _____ CIR: _____ URF: _____

PAPERWORK UPDATE ☐

PARTS MUST COMPLY ☐

PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance / Customer Support Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Airbus	N			
3	Notify Leonardo	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Update Product Compatability Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10		N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	MD		<i>mpp 19.01.15</i>
12	Update Product Specification Files (Bluefiles)	N			
13	Update Approved/Preliminary Dwg PDF Files	Y	MD		<i>mpp 19.01.15</i>
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	mg	<i>parts exist (RBE+ mem#)</i>	<i>mpp 19.01.15</i>
17	Update / Verify Authorized Release Certificate Database	N			
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	N			
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	N			
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

STOCK CAN BE USE
DELETE REV A

done w 19.01.15
WO# 185440

ECN Verified & Complete: _____ Date: _____

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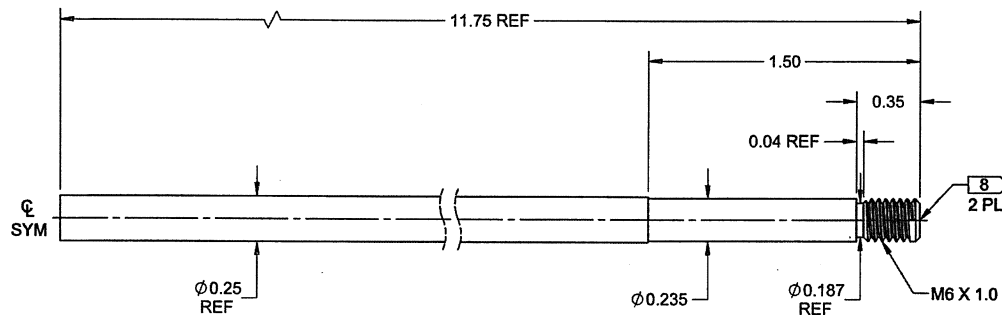
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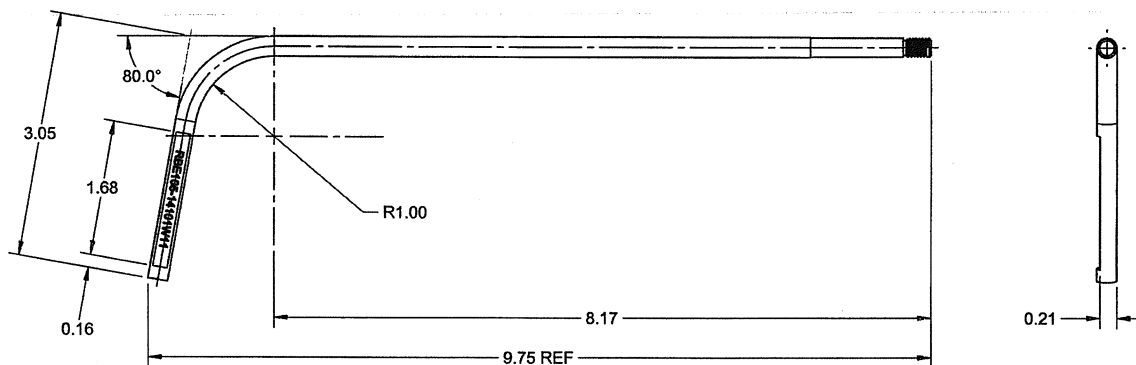
STOCK CAN BE USE
DELETE REV A

n/a *19.01.16*

ECN Verified & Complete: _____ Date: _____



FLAT PATTERN



RBE105-14101W11 EXTRACTOR

NOTES:

- 1) MATERIAL: McMaster#6628K23 OR EQUIV
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
- 8) CENTER DRILL IS ACCEPTABLE
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

B	UPDATED DRAWING TEMPLATE AND NOTES FINISH WAS ZINC PLATE IS BLACK OXIDE DIM WAS 0.235 IS 0.25. 0.235 ALONG 1.50 LENGTH OF ROD ONLY. DIM WAS 9.75 IS 9.75 REF. DIM WAS (2.95) IS 3.05. REMOVED 100° DIM. ADDED 80.0° DIM MATERIAL WAS 4140/4142 IS Mcm#		19-509	KPT
	1	RELEASED FOR PRODUCTION		RJC
REV.	DESCRIPTION		ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	KPT			
CHECKED	MB	TOOL PART #	REV. B	
MFG. APPR.	DP	RBE105-14101W11	SHEET 1 OF 1	
APPROVED	WJ	TITLE	SCALE	NTS
DATE 1/15/2019		EXTRACTOR		
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Dart Aerospace Ltd.
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Hawkesbury, ON
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Tel (613) 632-5200
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Job Operations

Job No: 185440

Part No: RBE105-14101W11 Job Qty: 5 ea

Material:

Op No	Operation	Op Qty	Start Date	Due Date	Center	Standard		Schedule		Actual					Inv	Job Op Note
						Setup Hrs	Run Hrs	Start Date	hrs	Status	Start Date	Completion Date	Setup Hrs	Run Hrs		
90	Start up Operation	5		11/16/18	Start Up Machining-4	0.00	0.00	11/16/18 12:00 AM	0.00	Completed	11/2/18 1:41 PM	11/2/18 1:46 PM	0.00	0.03		
120	Lathe Conv	5		11/16/18	Mill Conv 2	0.00	1.25	11/15/18 11:00 PM	1.25	Completed	11/2/18 1:43 PM	11/2/18 1:46 PM	0.00	1.27		
130	QC	5		11/16/18	QC2 Machining-5	0.00	0.00	11/16/18 12:00 AM	0.00	Completed	11/2/18 1:44 PM	11/2/18 1:46 PM	0.00	52.58	5	
140	QC	5		11/16/18	QC8 Machining-5	0.00	0.00	11/16/18 12:00 AM	0.00	New			0.00	0.00		
150	Small Fab	5		11/16/18	Small Fab-6	0.00	0.63	11/16/18 12:00 AM	0.63	New			0.00	0.00		
155	Conventional Mill - 1 - B4B	5		11/16/18	Conventional Mill - 1 - B4B	0.00	0.00	11/15/18 11:00 PM	1.25	New			0.00	0.00		
156	QC 2	5		11/16/18		0.00	0.00			New			0.00	0.00		
160	QC 8	5		11/16/18	QC5	0.00	0.00	11/16/18 12:00 AM	0.00	New			0.00	0.00		
170	Packaging	5		11/16/18	Packaging3-2	0.00	0.00	11/16/18 12:00 AM	0.00	New			0.00	0.00		
180	QC21-SA	5		11/16/18	QC21	0.00	0.00	11/16/18 12:00 AM	0.00	New			0.00	0.00		